

# Work Order ID 76952

November-24-11 11:22:35 AM

**\*76952\***

Page 1

Item ID: D1049

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Saddle

Start Date: 24/11/2011 Start Qty: 40.00 **\*40\***

Cust Item ID:

Required Date: 01/12/2011 Req'd Qty: 40.00 **\*40\***

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/11/24

Tooling:

Date:

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D1049	<del>Rev A</del>
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100

0.00

**\*100\***

SHEAR

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blanks: 2.000" long

110

0.00

**\*110\***

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per folio FA217 & Dwg D1049  
2-Deburr

120

0.00

**\*120\***

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 76952

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Item ID: D1049 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle  
 Start Date: 24/11/2011 Start Qty: 40.00 **\*40\*** Cust Item ID:  
 Required Date: 01/12/2011 Req'd Qty: 40.00 **\*40\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC8- Insp parts - second check 0.00

**\*130\***

QC Memo 0.00

Quality Control

140 Chemical Conversion Coat per QSI005 4.1 0.00

**\*140\***

HandFinish Memo 0.00

Hand Finishing

150 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 0.00

**\*150\***

Powdercoat Memo 0.00

Powder Coating

Memo  
 START TIME: 9:00  
 OVEN TEMPERATURE: 320 °F  
 FINISH TIME: 9:30

W115128

10xØ m-12/01/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*76952\***

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Item ID: D1049 Accept **\*N900040100\*** Setup Start **\*NS1\***  
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 Item Name: Saddle  
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 Required Date: 01/12/2011 Req'd Qty: 40.00 **\*40\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location <b>CA</b>	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

10 BL 12-1-13.

12/1/16 **10**

12/1/16 **MF**

12-01-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

November-24-11 11:22:39 AM

Page 1

Work Order ID: 76952

**\*76952\***

Parent Item: D1049

**\*D1049\***

Parent Item Name: Saddle

Start Date: 24/11/2011

Required Date: 01/12/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP RevC02.04.10Re-formatNG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X00.25 0		Purchased	No			100	f	12.0820	0.1666	7.014737			

**\*M6061T6B0 750X00 250\***

**\*\***

6061-T6 Bar .750 x .250

Location

Loc Qty

Loc Code

MAT003

12.082

114968

12.082

M120129

1.8 f ~~10~~ 12/01/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

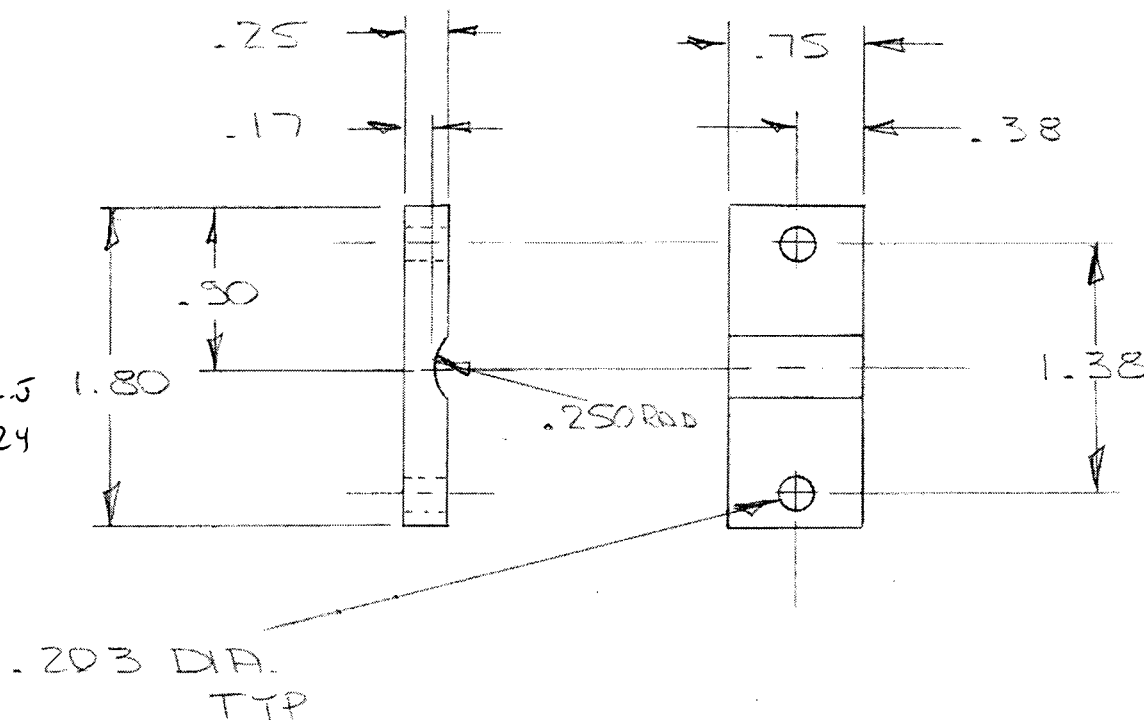
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RELEASED  
97/08/02 B.W.

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SUBJECT TO AMEND  
WITHOUT NOTICE  
WORK COPY  
NO. 76952 M.C.S  
11/11/24



MATERIAL: ~~5052-H32~~  
6061 T6  
FINISH: POWDER COAT



REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPO OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC/VENDOR
DRAWN			BASIC CODE		CONTRACT NO.		DART AERO ACCESSORIES INC. VANCOUVER CANADA		
APPROVED			DIA. DASH NO. W=HEAD REAR SIDE P=HEAD FRA SIDE		DRAWN DESIGN STRESS CHECKED CLIENT		DATE 11/11/24 1992		
DESCRIPTION	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL LIMITS 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 µ 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH — 8 — 7742 5. HOLEX PER AND 10367		1. TOLERANCES — .XX .030 .XXX .010 2. ANGLES 1 94° 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL MFC CENTRE LINES .005		BASIC CODES LP=MS20470AD BB=NAS 20476AD		TITLE SADDLE CODE DWG NO. D1049 SCALE 1:1 SHT OF 1		
OF	REPORT ALL DISCREPANCIES — DO NOT SCALE								
CHANGE									

W/O:		WORK ORDER CHANGES					
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